

Work Order ID 55024

January 5, 2010 1:18:50 PM



Page 1

Item ID: D3564-5

Accept

Setup

Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

PL

Date: 10-1-05

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3564	Rev D
-------	-------

100 0.00



FLOW WATER JET

Waterjet	Memo	0.00
----------	------	------

FLOW CNC Waterjet	1-Cut as per Dwg D3564	Dwg Rev: <u>D</u>	Prog Rev: <u>D</u>	02-
-------------------	------------------------	-------------------	--------------------	-----

Deburr if necessary

304.063

PL 10-1-11

(12)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC	Memo	0.00
----	------	------

Quality Control		
-----------------	--	--

HB 10-1-11

120 QC8- Inspect parts - second check 0.00

QC	Memo	0.00
----	------	------

Quality Control		
-----------------	--	--

2010/01/12

(12) f

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 55024



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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

130



NC BRAKE

0.00

12

Brake NC

Memo

0.00

SB 1401/13

Brake NC

Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155. Form Joggle as per Dwg D3564 on brake using Jig DT8157

140



QC5- Inspect part completeness to step on W/O

0.00

=> SB 1401/13

QC

Memo

0.00

(X12)

Quality Control

Ensure joggle as per dwg D3429

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112598

=> M1 10-01-13 (X12) Q

Powdercoat

Memo

0.00

START TIME: 10:00AM

OVEN TEMPERATURE:

10:30AM FINISH TIME:

320°F

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January 5, 2010 1:18:50 PM

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Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160

QC3- Inspect Part Finish



QC

Memo

Quality Control

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00	BR	10-01-13		12	0		
0.00							

170

Identify as per dwg & Stock Location



Packaging

Memo

Packaging

0.00	10-01-13	(12)	0
0.00			

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/01/14
MF 10-1-13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:18:53 PM

Page 1

Work Order ID: 55024



Parent Item: D3564-5



Parent Item Name: Wearshoe

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	370.2779	18.9474			

304/316 Sheet .063



Warehouse Location	Loc Qty	Loc Code	_____
MAT	370.2778737		_____
106860	8.0295		_____
111924	25.1689737		_____
112442	29.8899		_____
113295	307.1895	13295	13295

(12)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55025
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>FB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-1-11	Date: 10/01/12	Date: N/A

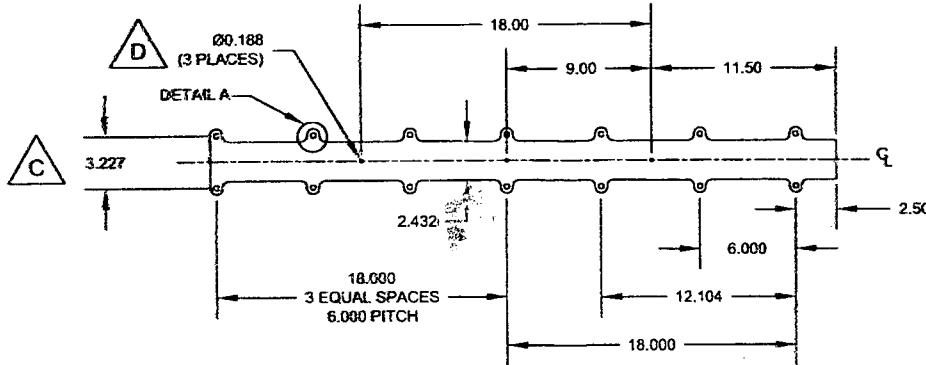
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DR	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

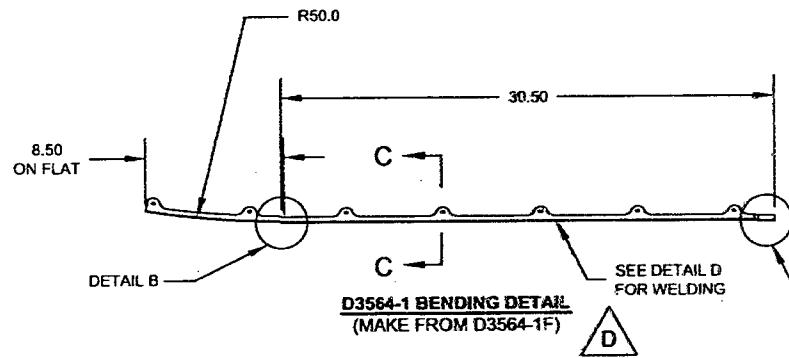
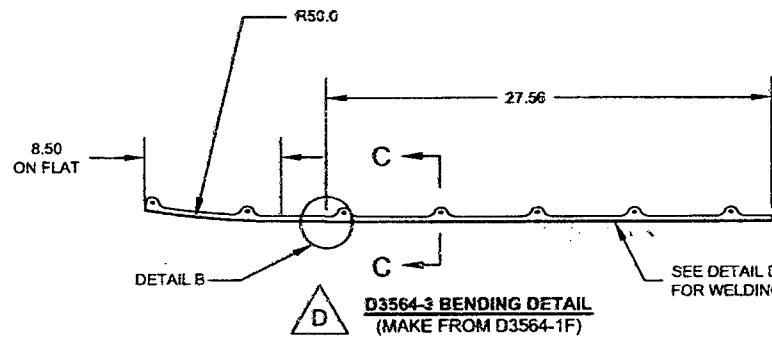
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NOTE: Date & initial all entries



RELEASED

07.09.04

D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

SHOP COPY

PICTURE TO

ENLARGING

UNCONTROLLED CO

SUBJECT TO ANNUAL MA

WITHOUT NOTICE

WORK ORDER

NO. 55024*11/10/05*

3564-1/3-5/7-9/11-13/15 WEARPLATE NOTES:

) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)

) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3

) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

) UNITS: INCHES UNLESS OTHERWISE NOTED

) BREAK SHARP EDGES: 0.005 TO 0.015 MAX

) IDENTIFICATION: NONE

) WEIGHT: SEE TABLE IN ZONE A3

) WELD PER DART QSI 004

) SEE PG 3 FOR SECTIONS AND DETAILS

) PARTS ARE SYMMETRIC ABOUT C

SUBJECT TO ANNUAL MA

WITHOUT NOTICE

WORK ORDER

NO. 55024*11/10/05*

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D UPDATE DRAWING TEMPLATE;
CHANGE ALL (TYP X PLS) TO (X PLACES);
PG1 A6: UPDATE NOTES;
PG1 A8, PG3 B5, C5: ADD D3564-15;
PG1 B6, B3: D3564-1/3 WAS ONE FIGURE;
PG2 A7, A3: D3564-9/11 WAS ONE FIGURE;
PG2 A7, A3: D3564-9/11 WAS ON PG1;
PG3 B8, C8: D3564-13 WAS ON PG2;
PG3 C2: WELDING DETAIL WAS ON PG1;
PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION;
PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE

CB 07.08.21

C MOVE TAB OUTBOARD, DETAIL A

PH 07.04.17

B ADD AMS 5513 AND AMS 5524

PH 07.03.26

A NEW ISSUE

PH 06.12.18

REV. DESCRIPTION BY DATE

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>PH</i>	D3564	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	WEARSHOE	1:6
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

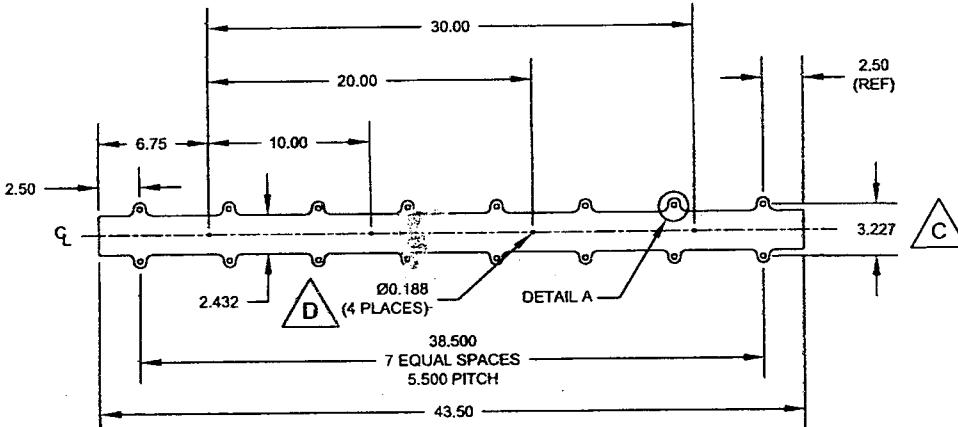
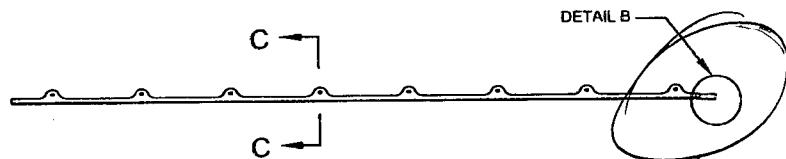
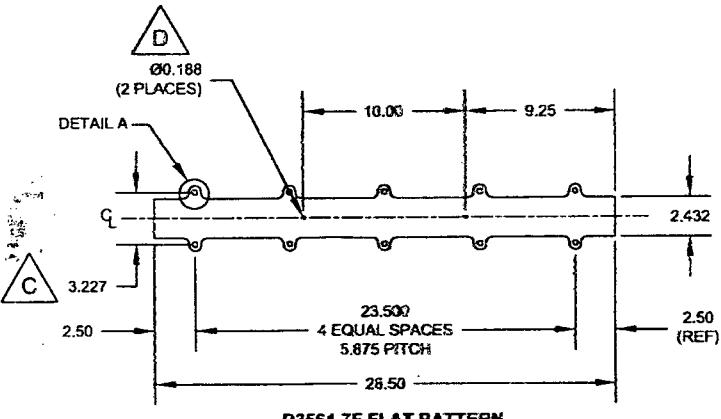
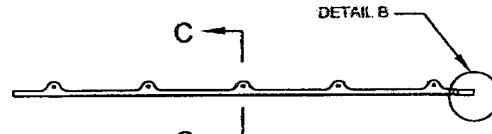
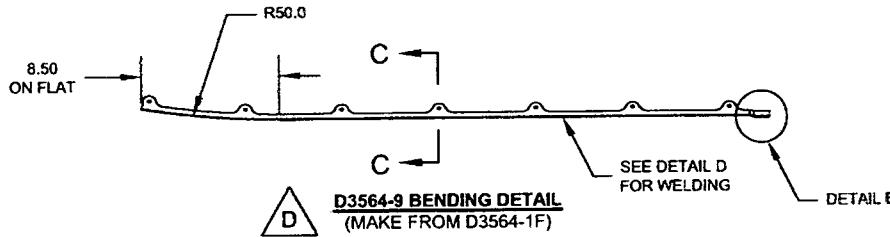
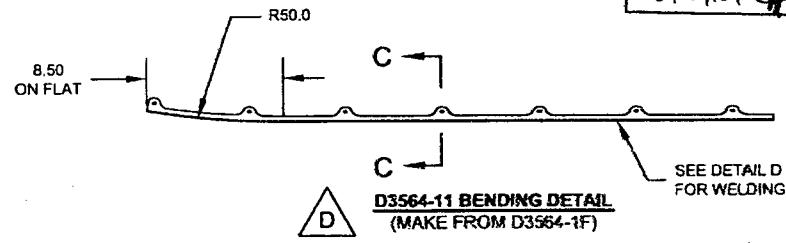
5

4

3

2

1

D3564-5F FLAT PATTERND3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)D3564-7F FLAT PATTERND3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04 ~~07.09.04~~SEE DETAIL D
FOR WELDING

u/1 55024

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	
MFG. APPR.	PH	REV. D	
APPROVED	PH	SHEET 2 OF 3	
DE APPR.	PH	TITLE WEARSHOE	
DATE	07.08.21	SCALE 1:8	

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8

7

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5

4

3

2

1

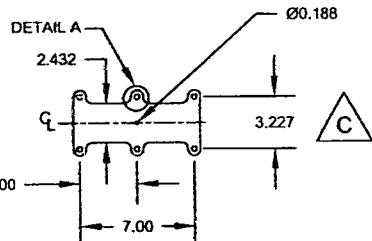
W/O:		WORK ORDER CHANGES					
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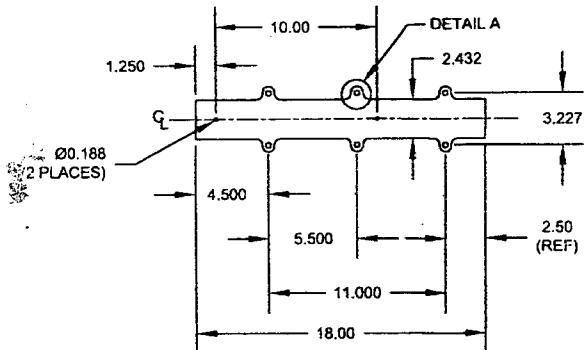
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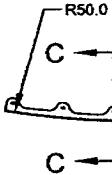
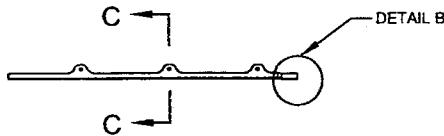
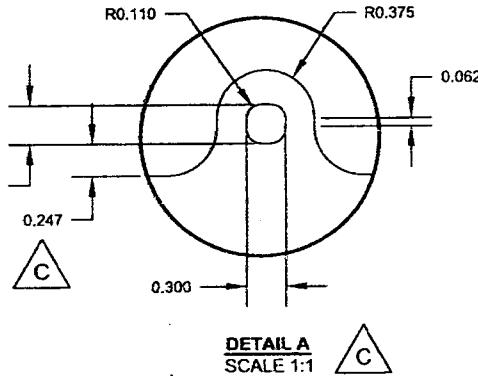
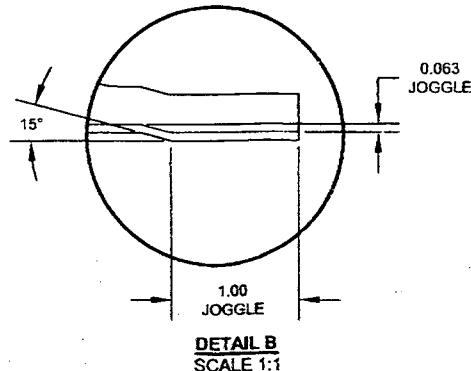
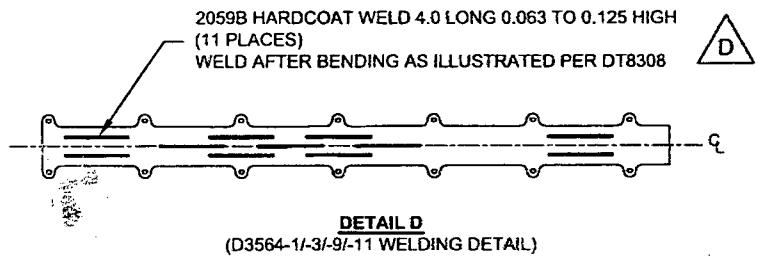
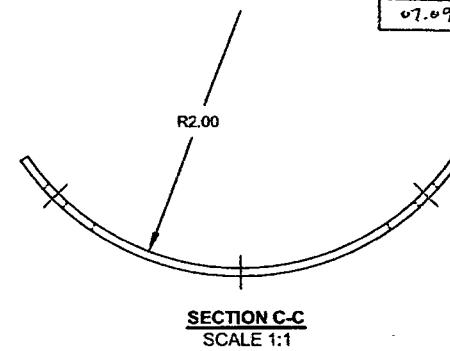
NOTE: Date & initial all entries



D3564-13F FLAT PATTERN



D3564-15F FLAT PATTERN

D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)DETAIL A
SCALE 1:1DETAIL B
SCALE 1:1DETAIL D
(D3564-1/3/9-11 WELDING DETAIL)RELEASED
07.09.04SECTION C-C
SCALE 1:1

w/6 55024

DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3564
MFG. APPR.	SH	REV. D
APPROVED	SH	SHEET 3 OF 3
DE APPR.	SH	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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